

Work Order ID 135935

Tuesday, August 25, 2015 7:27:20 AM

135935

Page 1

Item ID: D2654-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 8/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/25/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: AUG 25 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.06							
Skidtubes	1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.03							
Hand Finishing									

15-8-25

15-8-26

15-8-26

Work Order ID 135935

Tuesday, August 25, 2015 7:27:20 AM

135935

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location <u>LG002</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.02							
Quality Control									

15-8-26 DGL
15-8-26 DGL
MC5 AUG 27 2015
SAB 20150827

Picklist Print

Tuesday, August 25, 2015 7:27:23 AM

Page 1

Work Order ID: 135935

135935

Parent Item: D2654-5

D2654-5

Parent Item Name: Web

Start Date: 8/25/2015

Required Date: 8/25/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-7-140

Manufactured

No

100

Each

57.0000

1

10

D2600-7-140

15-8-25

[Signature]

EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

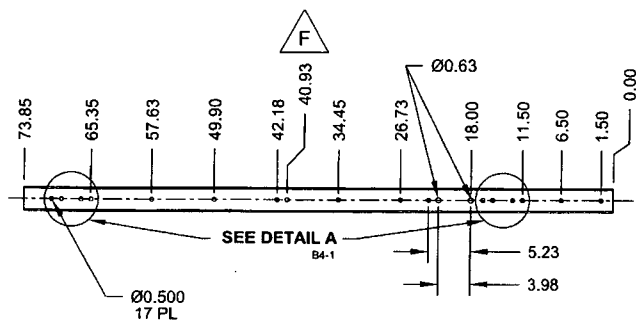
LG

57

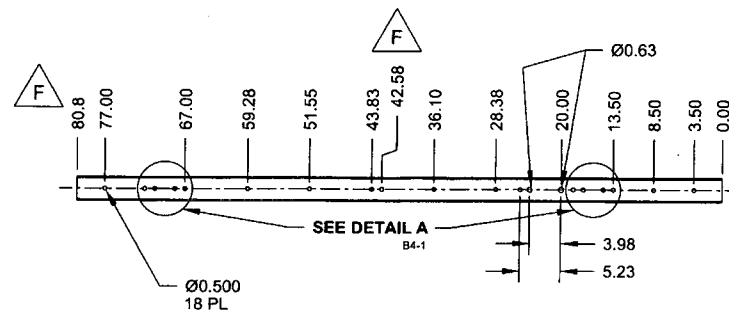
131525

57

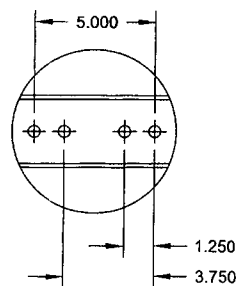
10



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

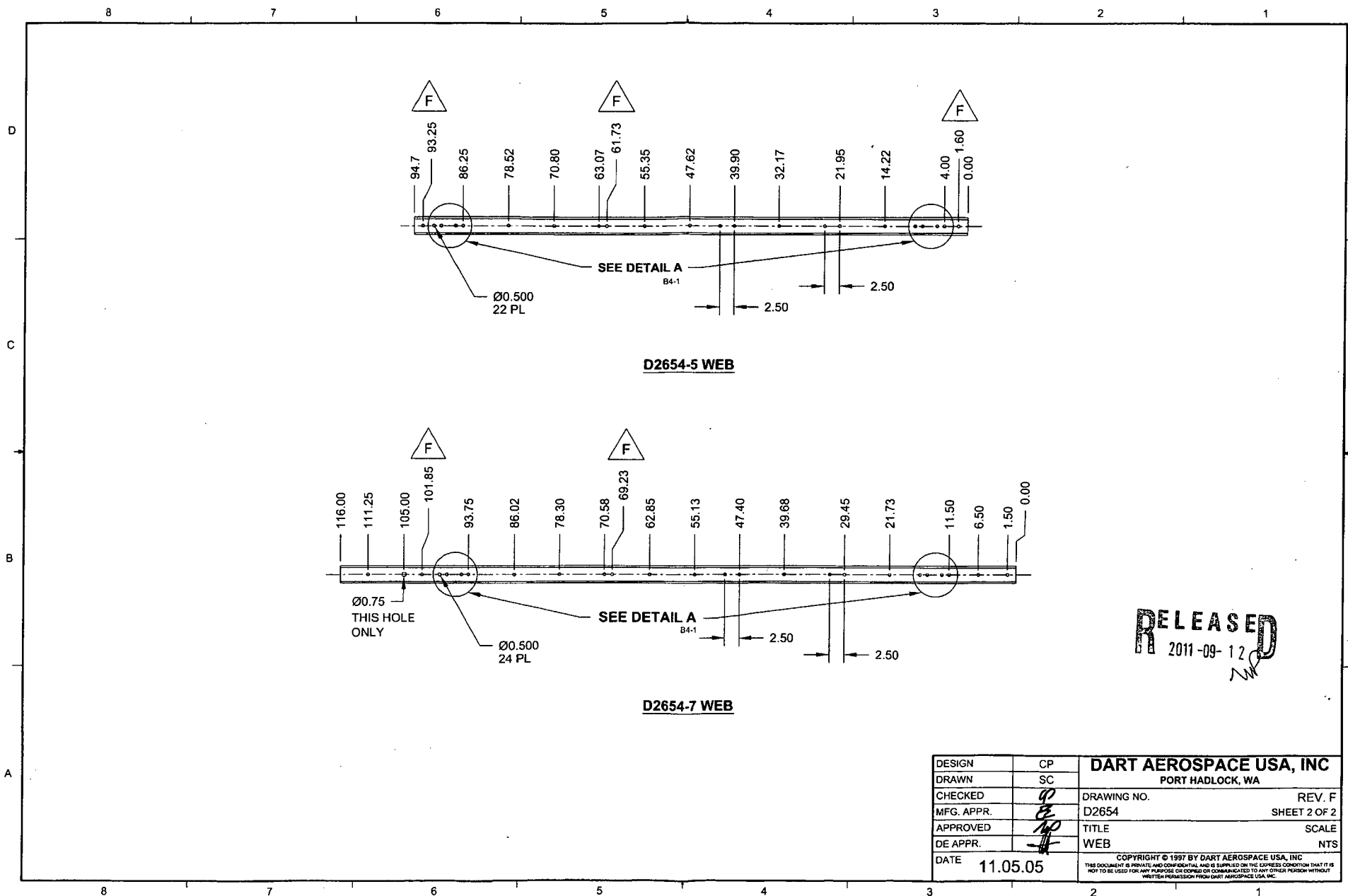
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2011-09-12
M

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 135935 MCLJ
1508-25

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D2654	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	WEB	NTS
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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D2654	SHEET 2 OF 2
APPROVED	90	TITLE	SCALE
DE APPR.	90	WEB	NTS
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